

Date: Thursday, 2/7/2008 8:51:50 AM
 User: Eric Charbonneau

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOOR DOUBLER
 Job Number : 37269
 Estimate Number : 13149
 P.O. Number :
 This Issue : 2/7/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D37011
 First Issue : / / Type : R & D SM/MED FAB Drawing Number : D3701 U/R
 Previous Run : 37135 Project Number : N/A
 Material :
 Due Date : 2/14/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A 08-01-30 new issue DD verified by:EC

PROTOTYPE

Additional Product

Job Number:



Seq. # Machine Or Operation: Description :

1.0 M6061T6S080 6061-T6 .080 Sheet



Comment: Qty.: 1.0545 sf(s)/Unit Total : 1.0545 sf(s)
 6061T6 aluminium sheet .080" thick
 (M6061T6S080)
 Batch: 104921 IB 8-2-7

CERTIFICATE OF CONFORMITY
 REQUIRED

2.0 WATER JET FLOW



Comment: FLOW WATER JET
 1-Cut as per Dwg D3701
 Dwg Rev: UR
 Prog Rev: 4/2 IB 8-2-7

2 prototyps
 made?

2- Deburr if necessary IB 8-2-7

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

ENGINEERING
 APPROVAL

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr if necessary

1/208.02.20

Date: Thursday, 2/7/2008 8:51:50 AM
User: Eric Charbonneau

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR DOUBLER

Job Number: 37269

Part Number: D37011

Job Number:



Seq. #:

Machine Or Operation:

Description :

2- form as per dwg D3701

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

180602-20

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



**ENGINEERING
APPROVAL**



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

NIA

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

FOR ENGINEERING USE ONLY

180602-20

10.0

QC21

FINAL INSPECTION/W/O RELEASE



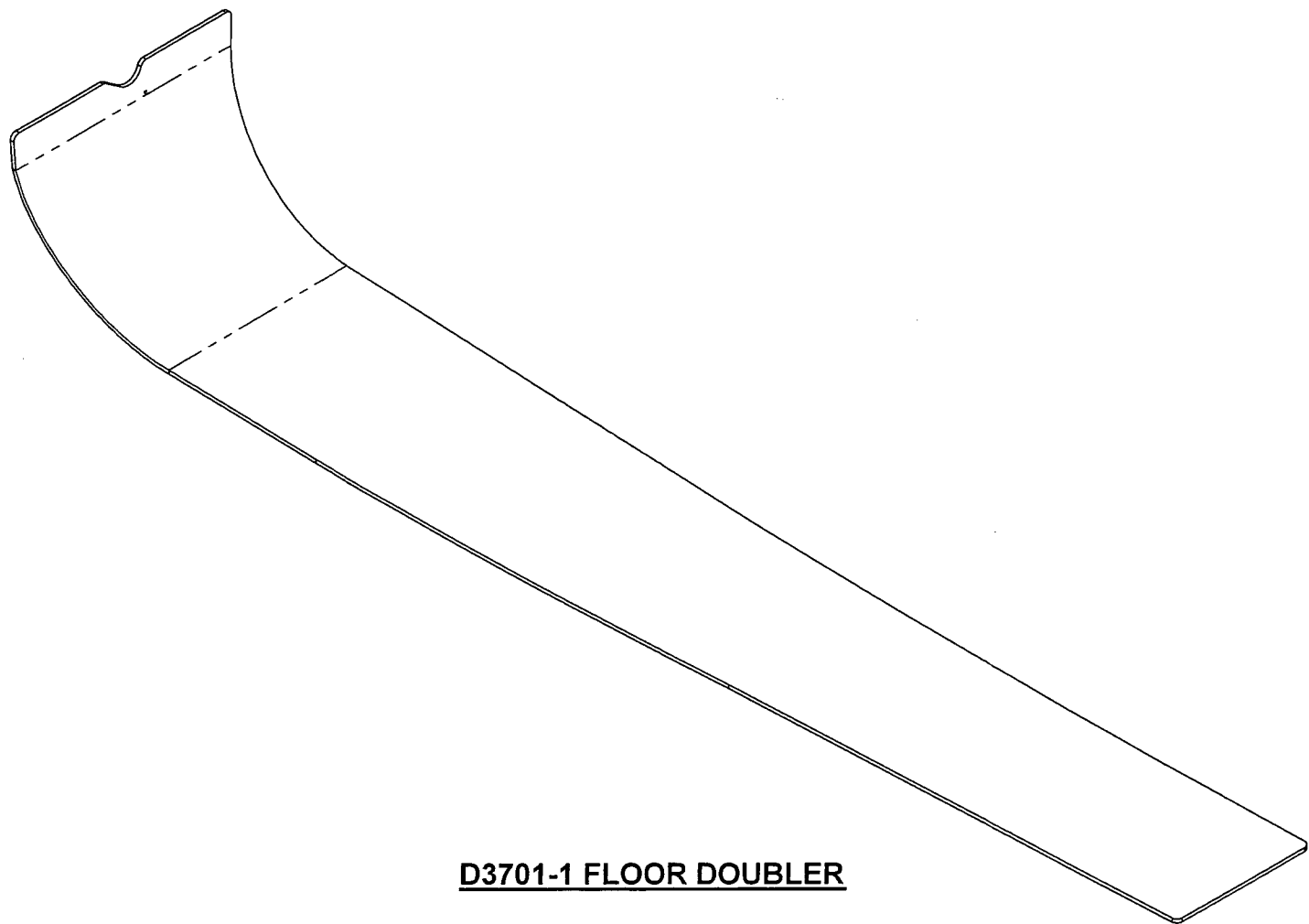
Comment: FINAL INSPECTION/W/O RELEASE

180605120

Job Completion



UMF 08-05-16




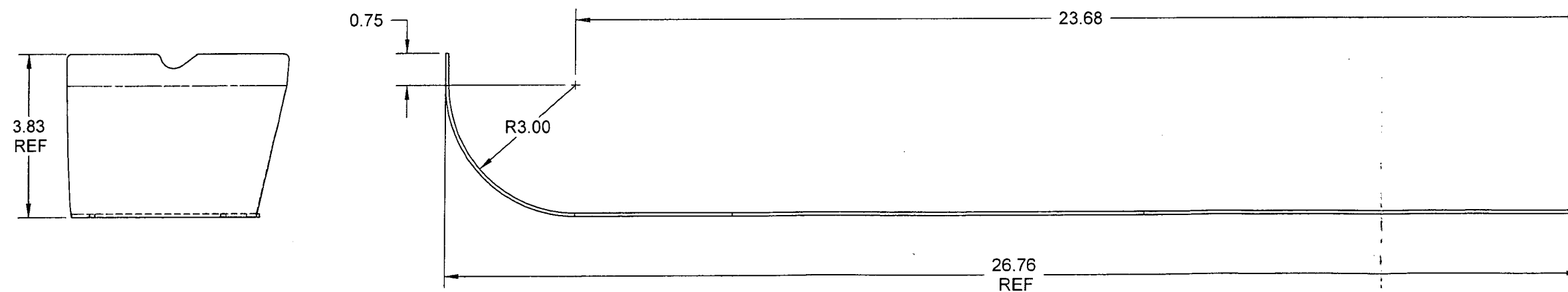
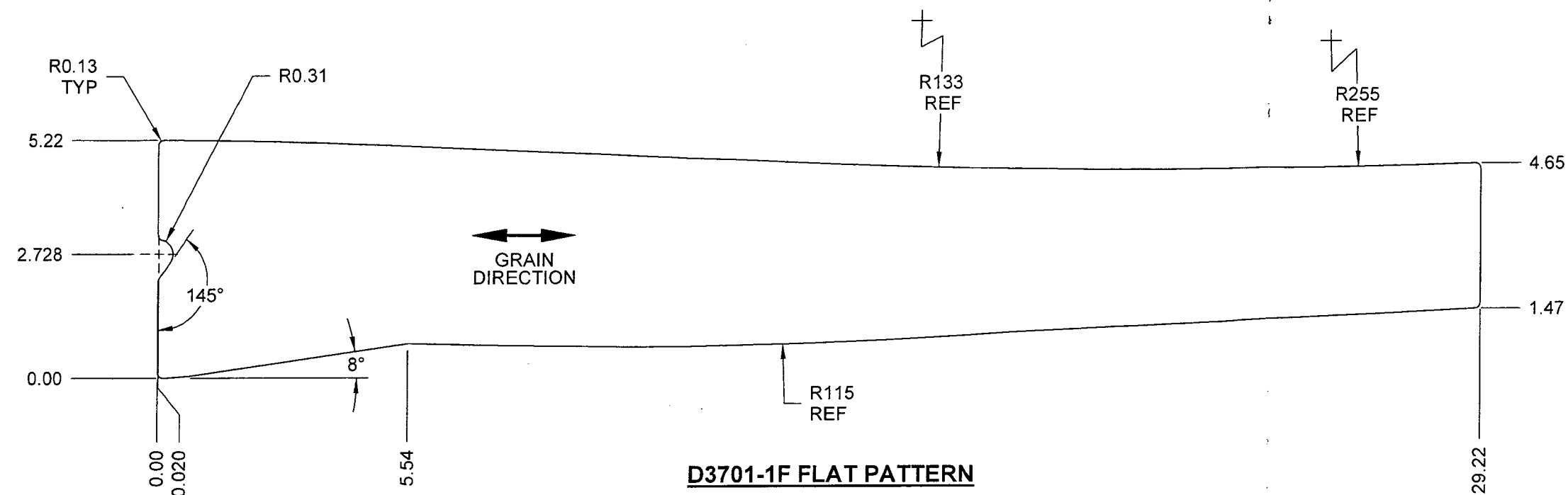
D3701-1 FLOOR DOUBLER

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.89 lbs

PRELIMINARY ISSUE
08.02.06

A	NEW ISSUE		MB	08.02.06
REV.		DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D3701	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.		FLOOR DOUBLER	1:3	
DATE	08.02.06	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		



D3701-1 FLOOR DOUBLER
(MAKE FROM D3701-1F)

PRELIMINARY ISSUE

02-020

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. REV. A
MFG. APPR.		D3701 SHEET 2 OF 2
APPROVED		TITLE SCALE
DE APPR.		FLOOR DOUBLER 1:3
DATE 08.02.06		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Date:

07/07/09

Batch No:

1104921

Supplier:

Campi

Dart P/O:

4054

Packing Slip:

Yes ☒ No ☐

Invoice:

Yes ☒ No ☐

Receipt:

Cash ☐ Cr ☐

Release Note Attached:

Yes ☒ No ☐ N/A ☐

Waybill Attached:

Yes ☒ No ☐ N/A ☐

Shipment Complete:

Yes ☒ No ☐ N/A ☐

QC6 Inspection

on plate ☒ N/A ☐

Work Order

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
	M30480150X250	12	0	0	12	
	M3045256A	32	0	0	32	
	M413011050010300	40	0	0	40	

Initials of receiver (if shipment OK) Level 12

Production/Admin:

07/07/09

Date

Received/Costing

RCP 5032

Initial

CP

Location

H:\FORMS\Purchasing\approved purchase\REPORT Rev D

50 377-4248
50 377-5696MONTREAL : 514 336-4248
FAX : 514 336-4246DISTRIBUTEUR D'ACIER ET METAUX SPECIALISES
STEEL AND SPECIALTY METALS DISTRIBUTORONTARIO : 1 800 667-4248
FAX : 1 866 456-4242

On a du Savoir "FER"

A / SHIP TO:

ROSPACE LTD
ERDEEN STREET
URY,FACTURE
INVOICE

N° 176759

DATE

04/07/07

BON DE LIVRAISON
PACKING SLIP

N° 123473

DATE DE LIVRAISON
DELIVERY DATE

04/07/07

TERMES / TERMS

NET 30 JOURS

TERR.

2R

REMARQUES / REMARKS

PAGE N°

001

DESCRIPTION	POIDS WEIGHT	PRIX PRICE	PAR PER *	MONTANT AMOUNT
.080 12'	192	5.700		1094.40
.040 8'	128	2.500		320.00
.063 12'	144	20.500		2952.00
.080 12'	144	25.650		3693.60
X 2.5	0	35.400		0.00
3/8 X .035	120	1.750		210.00
1/2 X 3	0	31.500		0.00

POIDS TOTAL
TOTAL WEIGHT

728.00

Formplus N° 8819

MATERIALS REMAIN THE PROPERTY OF "ACIER CAMPI INC." UNTIL PAYMENT IS MADE IN FULL, COMPLETE AND CASHED.
 THE BUYER'S EXPENSE. • ALL MATERIALS BEAR THE SAME WARRANTY AS GIVEN BY THE MANUFACTURER.
 TO RESPECT THE FOLLOWING CONDITIONS: NET 30 DAYS FROM BILLING DATE AND THE BUYER ACCEPTS TO PAY
 2% PER MONTH OR 24% PER ANNUM ON ALL PAST DUE ACCOUNTS OVER 30 DAYS. • ANY DEFAULT IN RESPECT WITH
 PAYMENT BY ACCELERATION AND PERMITS TO THE SELLER, AT HIS CHOICE TO CLAIM FOR THE BALANCE DUE OR THE
 SOLD. • ANY CLAIM MUST BE MADE WITHIN FIVE DAYS WITH THIS DOCUMENT ENCLOSED. • ANY MERCHANDISE
 CUT OR MODIFIED CANNOT BE RETURNED. • ALL GOODS RETURNED MUST BE WITH OUR AUTHORIZATION AND ARE
 CHARGE.

EN BONNE CONDITION MERCHANDISE RECEIVED IN GOOD CONDITION

A/Y M/M J/D

CLIENT / CUSTOMER'S SIGNATURE

DATE

SOUS-TOTAL
SUB TOTAL

8270.00

T.P.S.
G.S.T.

496.20

T.V.Q.
Q.S.T.

0.00

TOTAL

8766.20

CERTIFIED INSPECTION REPORT

We hereby certify that the material sampled by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material and the sample taken have been tested and the mechanical properties shown on the face of this sheet.

Mark J. Webb

Mark J. Webb
Director of Manufacturing Development

Kenn P. Young

Kenn P. Young
Quality Assurance Manager

Ship From:

731866	0		
Ship Date	B.L. No.	Invoice No.	Alcoa No. Item
2007-02-19	2002189	00000	4437904-1
P.O. No./Govt Contract No.	Customer	Mfg Order	

Page 1

W61242R
our B0866721

Ship To:

Item Description
0.08 IN TX (+0 -.0045) X 48.0 IN W X 0.046875 -
0.046875) CAT X G0415462R03 (N/A/T 6061-T6)
COIL SHEET FOR DISTRIBUTORS TOLERENCE GUARANTEED. AMS-QQ-A-
250/11 AMS4027 REV M ANSIN35.2 REV 2006 ASME-88-
209 REV A99 ASTM209 REV 06 (NOT
MARKED) LIGHTLY OILED COIL SIZES: ID 20 IN
COIL WTS: MAX 8500 LB
MAX GROSS SKID WGT: 7000 LB QUAN TOL +/-10
1 CQR D138487 REV 31 CUST REQ 07-02-
17 *** N/B 07-02-24 ***

on 2/2/06

Num	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serial
1	492938	555791	4861	1	PC	D035909
2	496818	587268	6410	1	PC	D035908
			11271	2		

Notes for CQR: D138487.31

PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/11 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/11P. PROD UCT
PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/11 P ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/11.

CQR: D138487.31 -Specification Limits

Temp	Dir	UTS	TYS	ELAD
T6	Long Transv.	KSI	KSI	PCT
	Max			
	Min	42.0	35.0	10

Chemical Composition	SI	FE	CU	MN	MG	CR	ZN	TI	Other	Other
	Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.03
	Min	0.40	0.15	0.04	0.04					
Alloy 6061										
Lot: 555791										

- Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	Mo	UTS	TYS	ELAD
T6	Long Transv.	Test	KSI	KSI	PCT
		2	49.7	44.7	11.1

CERTIFIED INSPECTION REPORT

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material and the composition have and had the mechanical properties shown on the face of this sheet.

Mark J. Vetter

Mark J. Vetter
Director of Manufacturing Development Works

Kurtis P. Young

Kurtis P. Young
Quality Assurance Manager

731866

Ship Date

2007-02-19

P.O. No./Govt Contract No

W61242B

0

B.L. No.

2081389

Invoice No.

00000

Customer

BAKKEE SON & CO LS DS-37904-1

Ship From:

RIVERDALE, IA.

Alcoa No. Item

4437904-1

W6a Order

Page 2

Lot: 555791 - Mechanical, Physical, Metallography, Quantometer Results (cont.) -----
49.6 44.5 11.6

Cast Number	Chemical	SI	FE	CU	MN	MO	CR	ZN	TI
06J06551	Actuals	0.62	0.3	0.28	0.01	0.9	0.19	0.02	0.02

Lot: 587268 - Mechanical, Physical, Metallography, Quantometer Results -----

Temp	Dir	No. >	UTS	TYS	ELAD
Ts	Long Transv.	Test	KSI	KSI	PCT
		2	49.8	45.1	10.8
			49.6	44.8	11.4

Cast Number	Chemical	SI	FE	CU	MN	MO	CR	ZN	TI
88522033	Actuals	0.64	0.4	0.25	0.06	1.0	0.20	0.02	0.02

D 035909
D 035908